

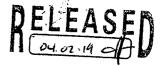
DART AEROSPACE LTD	Work Order:	23792
Description: Bracket Assembly	Part Number:	D3121-143
	10	
Dwg: D3121 Rev. C	Qty:	10 Kit(s) K
		Page 1 of 1

104.02.27

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	11		
		Dwg not required	934	05.07.12	10
2	MV	Cut blank: (1.000" x 2.000") 4.425" long	0		
1		Material: 17-4 SS Bar per AMS 5604/5643			
	•	(M17-4-B1.000x02.000)			
		Identify for D3121-113 Batch: MI4773	フル	05-07-13	10
3	MV	Machine D3121-113 as per Folio FA330 and Dwg D3121	0	,	
		Identify as D3121-113	27)	05/10/08	10
4	QC2	Inspect parts as they come off the CNC machine	E		
			TO .	05/00/08	20
5	MV	Deburr	En		
		<u> </u>	Est.	1.8/08	10
6	M∨	Scribe batch number	a		
			100	05/08/08	19
7	QC8	Second check		, 1	
			M	05/08/08	10
8	GA	Assemble D3121-143 as per Dwg D3121. \$23914			
		Pick: 13218819			
		Qty Part Number Description Batch	(
	. 1	2 D3121-21 Bolt <u>132 3459 A</u>	Ž	5/06/08	12
	•	2 D3121-241 Bearing Assembly BZ185SC	U	6100100	
<u> </u>	005	Identify as D3121-143			
9	QC5	Inspect work to Step 8	720	1.1	
10	<u> </u>	No. of Co. d.	12	0508/08	10
10	ST	Identify and Stock	M	dela	100
1 11		1	OL.	10180150	10
11	AC .	Cost / part 89.09	_	٠.	
			545	05-08-10	16
12	DC				
		Inspect Level 21 🗼		05/28/10	10

Rev	Date	Change	 Revised By	Approved
A.B.	04.02.18	New issue	KJ/DS	di

H 04.02.19



Dart Aerospace Ltd

	WORK ORDER CHANGES						
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
	STEP	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Mfg / Design Mgr	

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Annescal		
DATE	STEP	Description of NC Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector	
		·							
	,								
						!		·	

Part No:	PAR #:	Fault Category:	NCR:	Yes No DQA:	Date: 05/08/10
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

SWART TO CALL THE CAL					
DART-AEROSPACE-L	TD			Work Order:	23792
Description: Bracket			 400	Part Number:	D3121-113
70.00				•	
Inspection Dwg: D3121	Rev: C2	-			Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
40:080	+/-0.010	0.676				· · · · · · · · · · · · · · · · · · ·
0.300	+/-0.010	0.296				
R0.375	+/-0.010	0.37				
1.54	+/-0.030	1,538				
0.350	+/-0.010	0.354				
R0.250	+/-0.010	0.250				
1.800	+/-0.030	1. 800				
Ø0.392	+0.002/-0.000	0.392	_			
Ø0.201	+0.005/-0.000	0.707				- 10 C -
0.100	+/-0.010	0.102				
	,					
2.540	+/-0.010	2.536				
1.590	+/-0.010	1.587				
0.160	+/-0.010	6.159	_			
0.400	+/-0.010	0. 396	_			
1.220	+/-0.010	7.217	-			. M-4
1.600	+/-0.010	1.602				
3.80	+/-0.030	3.80	_			
1.800	+/-0.010	1.803	_			
R0.500	+/-0.010	0.560				
0.130	+/-0.010	0.179				
3.41	+/-0.030	3.41	-			-1
3.65	+/-0.030	3.659	V			
2.24	+/-0.030	2.24	/			
45°	+/-0.1°	450	/			
R0.250	+/-0.010	0.750	~			
3.97	+/-0.030	3973				1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
R0.38	+/-0.030	o. 345	1			
Ø0.392	+0.002/-0.000	0.392				
Ø0.201	+0.005/-0.000	0.702				
0.100	+/-0.010	0.102				
0.268	+/-0.010	0.262	/		_	
R0.260	+/-0.010	0.260				
0.080	+/-0.010	0.082	~			
0.300	+/-0.010	0.299	V			

HELEASED CAMPONOS.06

DART AEROSPACE L	TD	 Work Order:	23797
Description: Bracket		Part Number:	D3121-113
Inspection Dwg: D3121	Rev: C2		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

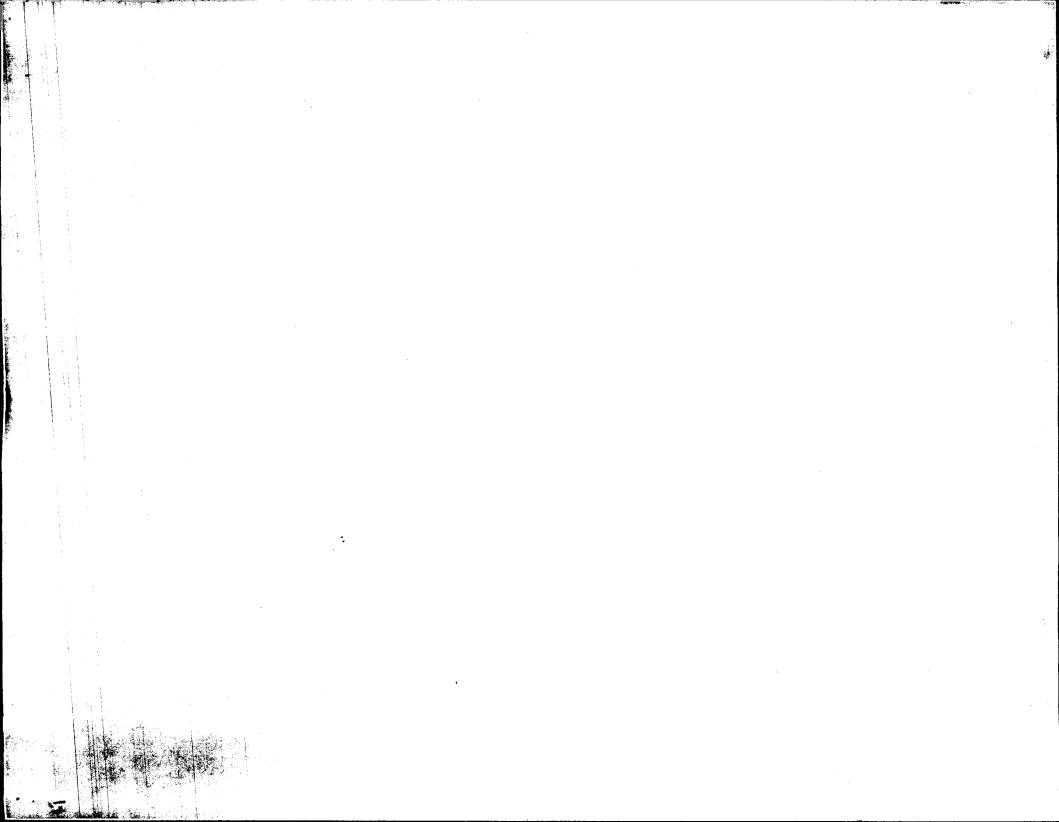
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
-0.381	+/-0.010	0.377	-	<u> </u>		
0.201	+/-0.010	0.207	-			191.00
0.580	+/-0.010	0.577				
0.400	+/-0.010	0.401	7			
100°	+/-0.1°	100	,			
8:32	+/-0.010	0-025				
००३१	. 3.3.0					
	ar					
					·	
			•.			
-						
						
				1		

Measured by:	Ep	Audited by:	Z	Prototype Approval:	N/A
Date:	05/08/06	Date:	05.08.06	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue P/O D3121-143	KJ/RF	1
В	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	7111
			1	1201





Job Costing Report .

Dart Aerospace Ltd. Hawkesbury

Jul 12, 2005

Work Order No : 0023792

Project Name : D3121-143 Project For : WK530

Work Order Type : Main

Main WO Number

House Part Number : D3121-143 Description : Bracket Assembly

Manufactured : Yes

Amount Req'd: 10 Amount Done : 0

Start Date : 07-12-05

Est Finish Date : 07-30-05 Act Finish Date :

Drawings Reqd Ok for Approval

Approval Rec'd :

: No

02:29 pm

Department Code:

Burden Flags : NNNNNNN WO Status : Open

Invoice State : Not Invoiced

Invoice Date

Invoice Number :

Invoice Amount : 0.00

Order Entry No :

OE Value 0.00

Est Mark Up : 0.000% Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	۷ar. %	Posted	To Post
	==		========			
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		========	========	======		
Burden	:	0.00	0.00	0.00		
				======		
Total Cost	:	0.00	0.00	0.00		
Mark up	:	0.000	0.000		•	
Selling Cost	:	0.00	0.00			•

		Estimated	Actual
Labour Hrs/Amount Done	:	0.00	0.00
Profits/(Loss)	:	0.00	0.00